

Work Order ID 52144

Thursday, September 17, 2009 8:09:16 AM

Page 1

Item ID: D209-669-013

Accept

Revision ID: B

Item Name: Skidtube LH

Start Date: 9/18/2009 Start Qty: 1.00

Required Date: 10/9/2009 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D209-669-013

Rev B

DSI 9450

Rev A

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP d209-669-013 CHG003

0.00

8/27/05

110

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

PC 9/10/05 (U)

52108

Work Order ID 52144

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Item ID: D209-669-013

Accept

Revision ID: B

Item Name: Skidtube LH

Start Date: 9/18/2009 Start Qty: 1.00

Required Date: 10/9/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

2) 8/21/05

+U

130

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD209-669-013
Location: _____

09/10/05

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/06

MF 09-10-05

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Work Order ID: 52144

Parent Item: D209-669-013RevB

Parent Item Name: Skidtube LH

Comments:

Start Date: 9/18/2009

Required Date: 10/9/2009



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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S D209-669-043RevB



Replacement Skidtube

 52108  9/18/09

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Premier		
Mezz	3	
22797	1	
39205	1	
39206	1	



S D2917-1RevB

Saddle LH

 52127 

S D2918-1RevB

Saddle LH

 52130 

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3	
43755	1	
51329	2	

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Work Order ID: 52144



Parent Item: D209-669-013RevB



Parent Item Name: Skidtube LH


Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-51A  Bolt		Purchased	No			110	Each	354.0000	8.0000	✓		

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	354	
110328	2	
111635	102	
112314	100	
112489	100	
112641	50	

11/12/14

D2570RevB



Bushing

Manufactured No

110 Each 139.0000 24.0000



52214 PC 9/17/09

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	15	
47246	15	
Main Warehouse		
ST36	124	
50356	124	

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Work Order ID: 52144



Parent Item: D209-669-013RevB



Parent Item Name: Skidtube LH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S MS21042L4 		Purchased	No			110	Each	8,148.000	24.0000	✓		
Nut											LC 9/10/05	

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	8148	
107499	5	
108145	4	
110450	1	
110507	184	
111827	5996	
112314	1893	
15924	0	
7690	24	
8182	41	

M112314

AN5-36A

Purchased

No

110

Each

555.0000

4.0000



Bolt

LC 9/10/05

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	555	
109545	11	
110467	7	
110731	4	
112243	20	
112314	463	
112385	50	

M112314

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Work Order ID: 52144



Parent Item: D209-669-013RevB



Parent Item Name: Skidtube LH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516 Washer		Purchased	No			110	Each	1,097.000	8.0000			

1112794

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1097	
100564	2	
106167	6	
107534	34	
107959	43	
108246	46	
108672	2	
109059	49	
109752	22	
110363	46	
110523	57	
111279	43	
112082	247	
112314	500	

MS21042L5

Purchased

No

110

Each

1,279.000

4.0000



Nut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1279	
110382	10	
111636	269	
112314	1000	

1110636

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Work Order ID: 52144



Parent Item: D209-669-013RevB



Parent Item Name: Skidtube LH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN4-7A		Purchased	No			110	Each	201.0000	16.0000			
--------	--	-----------	----	--	--	-----	------	----------	---------	--	--	--



Bolt



7/12/99 P 9/14/00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

201

111668

1

112314

50

112385

50

112641

100

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Work Order ID: 52144



Parent Item: D209-669-013RevB



Parent Item Name: Skidtube LH


Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416  Washer		Purchased	No			110	Each	8,313.000	32.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	8313
102929	2
105906	4
106277	2
107321	23
107939	114
108161	553
108827	31
109249	69
110523	340
111279	101
111916	2187
112314	4887
16941	0

11/19/06

D2929RevB

Manufactured No

110

Each

15.0000

2.0000



Spacer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	15
43376	15

52243 9/10/09

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Work Order ID: 52144

Parent Item: D209-669-013RevB

Parent Item Name: Skidtube LH


Comments:


Start Date: 9/18/2009

Required Date: 10/9/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S D2930RevB  Spacer		Manufactured	No			110	Each	11.0000	2.0000			

52249 

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

11

43378

11

D3405-041RevB

Manufactured

No

110


Each

10.0000

1.0000



Lug Assembly

51673 

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

10

51254

10

AN4C47A

Purchased

No

110

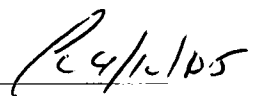
Each

222.0000

4.0000



Bolt

1112816 

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

222

110847

4

112431

18

112489

100

112641

100

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Work Order ID: 52144



Parent Item: D209-669-013RevB



Parent Item Name: Skidtube LH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-4 Nut		Purchased	No			110	Each	1,397.000	5.0000			

Warehouse
Location

Loc Qty

Loc Code

OFFSHORE

FG 40

104603 40

Main Warehouse

ST 1357

111819 35

112243 22

112314 1000

112492 300

D3405-043RevB

Manufactured

No

110

Each

12.0000

1.0000



Lug Assembly

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST 12

46589 1

46863 1

51255 10

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Work Order ID: 52144



Parent Item: D209-669-013RevB



Parent Item Name: Skidtube LH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3407-041RevE Manufactured No

110

Each

35.0000

1.0000



Tow Ring

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

3

35780

3

Main Warehouse

ST

1

48356

1

Main Warehouse

ST464

31

51659

31

D3456-1RevA

Manufactured No

110

Each

232.0000

1.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

7

25701

7

Main Warehouse

ST

225

46752

25

51653

200

51659

✓

PC 9/17/09 ①

51653

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Work Order ID: 52144



Parent Item: D209-669-013RevB



Parent Item Name: Skidtube LH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3417-5RevE

Manufactured

No

110

Each

152.0000

2.0000

✓



EC 9/18/09

Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

152

51649

152

51649

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52144

INSTRUCTIONS:

1) FOR D209-669-011/-012/-013/-014 SKID TUBES @ CHANGE 003 AND SUBSEQUENT, MODIFY THE FOLLOWING:

- a) REPLACE THE D2968-041 TOW RING WITH THE D3407-041 TOW RING ASSEMBLY.
- b) REPLACE THE D2736-1 AND D2736-3 GHW LUGS WITH THE D3405-041 AND D3405-043 LUG ASSEMBLIES.
- c) AMEND THE PARTS LIST IN SECTION 5.0 OF INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B AS SHOWN ON PAGE 2 OF THIS DSI.

NOTE: ALL INSTALLATION FASTENERS FOR THE ABOVE CHANGES HAVE BEEN UPDATED. SEE THE AMENDED PARTS LIST ON PAGE 2 FOR DETAILS.

A	NEW ISSUE	AJS	09.02.24
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
DATE	09.02.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

5.0 PARTS LIST

52144

ITEM	QTY -011	QTY -012	QTY -013	QTY -014	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X						D209-669-011	SKIDTUBE INSTALLATION, LH (AH-1W/J)
		X					D209-669-012	SKIDTUBE INSTALLATION, RH (AH-1W/J)
			X				D209-669-013	SKIDTUBE INSTALLATION, LH (AH-1P/F/S)
				X			D209-669-014	SKIDTUBE INSTALLATION, RH (AH-1P/F/S)
	1	1			X		D209-669-041	REPLACEMENT SKIDTUBE (AH-1W/J)
			1	1		X	D209-669-043	REPLACEMENT SKIDTUBE (AH-1P/F/S)

IS:

50	4	4	1	1			D3405-041	LUG ASSEMBLY
51	8	8	4	4			AN4C47A	BOLT
52	16	16	8	8			D2570	BUSHING
53	8	8	4	4			MS21043-4	NUT
54			1	1			D3405-043	LUG ASSEMBLY
60	1	1	1	1			D3407-041	TOW RING ASSEMBLY
61	1	1	1	1			D3456-1	WASHER
62	1	1	1	1			MS21043-4	NUT
63	2	2	2	2			D3417-5	WASHER

WAS:

50	4	4	1	1			D2736-1	GHW LUG
51	8	8	4	4			AN4-46A	BOLT
52	16	16	8	8			D2570	BUSHING
53	8	8	4	4			MS21042L4	NUT (OR MS21042-4)
54			1	1			D2736-3	GHW LUG
60	1	1	1	1			D2968-041	TOW RING
61	1	1	1	1			AN970-4	WASHER
62	1	1	1	1			MS21042L4	NUT (OR MS21042-4)

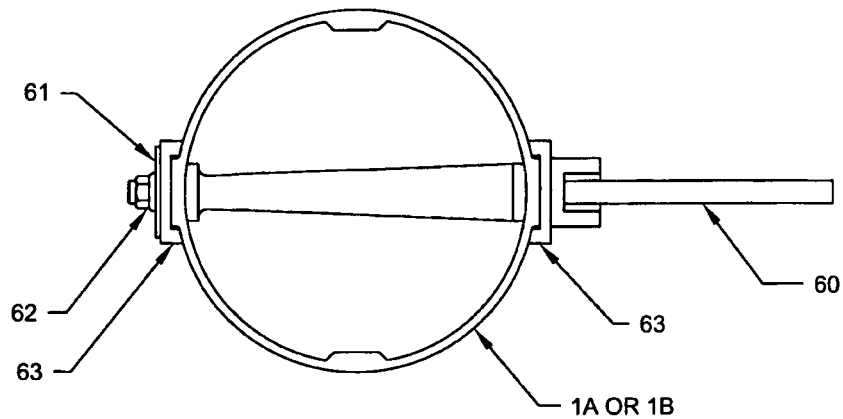
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO.
MFG. APPR.	N/A	DSI 9450
APPROVED		TITLE
DE APPR.		SKIDTUBE INSTALLATIONS
DATE	09.02.24	REV. A SHEET 2 OF 3 SCALE NTS

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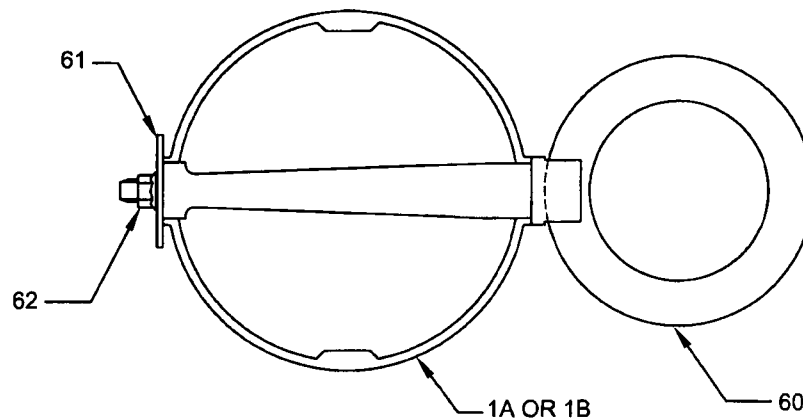
INSTALL TOW RING ASSEMBLY AS SHOWN BELOW (REFER TO SECTION F-F OF IIN-D209-669 REV. B.

52144

IS:



WAS:



NO PICTORIAL CHANGE REQUIRED FOR GROUND HANDLING WHEEL LUG CHANGES.

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
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